

Work Order ID 65843

Wednesday, January 26, 2011 11:34:35 AM

Page 1

Item ID: D412-698-038

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly, RH (Composite Doors)

Start Date: 1/26/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9484

B

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D412-698-038/ DSI9484
CHG001

Sub 1/17

for CL 11-02-17

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

11/2/17 SP

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

Sub 1/17

QA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65843

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Page 2

Item ID: D412-698-038

Accept

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Item Name: Bracket Assembly, RH (Composite Doors)

Start Date: 1/26/2011 Start Qty: 1.00

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Required Date: 2/7/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-038/ DSI 9484

Location: _____

PPP rev: A

11/21/17

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/02/18

MF

11-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:34:41 AM

Page 1

Work Order ID: 65843



Parent Item: D412-698-038



Parent Item Name: Bracket Assembly, RH (Composite Doors)

Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.11 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3675-6

Manufactured No

110

Each

0.0000

1

1



Sliding Door Bracket



B65845 11/2/17 sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION
AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43
REF. FAA STC: SR01446NY
REF. EASA.IM.R.S.00709

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits and forward D3675-1 brackets that are part of the D412-698-031/-032/-033 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kits that includes a longer D3199-3/-4 bracket for installation in the forward 2 positions of the D412-698-011/-012/-017 kits to reduce wear on these forward brackets on aircraft equipped with aluminum doors. Likewise, Dart has developed the D412-698-037/-038 kits that includes a longer D3675-5/-6 bracket for installation in the forward 2 positions of the D412-698-031/-032/-033 kits to reduce wear on these forward brackets on aircraft equipped with composite doors.

The D412-698-027/-028/-037/-038 kits may be installed as follows:

- 1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698
- 2) Remove the forward 2x D3199-1 or D3675-1 brackets as applicable.
- 3) Install the D3199-3/-4 or D3675-5/-6 bracket as applicable in lieu of the removed -1 brackets. Refer to Figure 1 Sheet 2 (aluminum doors) or Figure 2 Sheet 3 (composite doors).
- 4) Torque hardware per ICA-D412-698.
- 5) Re-install sliding door on aircraft per Section 52.2/52.3 of ICA-D412-698 as applicable.
- 6) Make entry in technical records of aircraft indicating that DSI 9484 has been completed.

PARTS LIST

QTY. -027	QTY. -028	QTY. -037	QTY. -038	PART NUMBER	DESCRIPTION
X			1	D412-698-027	BRACKET KIT, LH (ALUMINUM DOORS)
	X			D412-698-028	BRACKET KIT, RH (ALUMINUM DOORS)
		X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
			X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
1				D3199-3	FORWARD BRACKET, LH
	1			D3199-4	FORWARD BRACKET, RH
		1		D3675-5	FORWARD BRACKET, LH
			1	D3675-6	FORWARD BRACKET, RH

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal		Applicability
		Arm	Moment	Arm	Moment	
D412-698-027 Bracket Kit	0.33 lb 0.15 kg	-48.0 in -1.22 m	-15.8 in-lb -0.18 m-kG	102.3 in 2.60 m	33.76 in-lb 0.39 m-kG	Aircraft Equipped with P/N 205-032-669-XXX Aluminum Doors
D412-698-028 Bracket Kit	0.33 lbs 0.15 kg	+48.0 +1.22 m	+15.8 in-lb +0.18 m-kG	102.3 in 2.60 m	33.76 in-lb 0.39 m-kG	
D412-698-037 Bracket Kit	0.53 lb 0.24 kg	-48.0 in -1.22 m	-25.4 in-lb -0.29 m-kG	102.3 in 2.60 m	54.22 in-lb 0.62 m-kG	Aircraft Equipped with P/N 412-030-300-XXX Composite Doors
D412-698-038 Bracket Kit	0.53 lb 0.24 kg	+48.0 in +1.22 m	+25.4 in-lb +0.29 m-kG	102.3 in 2.60 m	54.22 in-lb 0.62 m-kG	

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.12.17
CERT. NO.: SH92-43
ISSUE NO.: 5

B	ADDED -037/-038 KIT FOR COMPOSITE DOORS; UPDATED TITLE ACCORDINGLY.	13	10.12.17
A	NEW ISSUE	15	09.10.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSI 9484 REV. B SHEET 1 OF 3 TITLE D412-698-027/-028/-037/-038 Kits SCALE NTS	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	N/A		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.12.17	COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	